

Work Order ID 85942

85942

Page 1

June-19-12 8:34:33 AM

Item ID: D2055

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clamp

Start Date: 19/06/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/19 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2055	Rev C1								
100		0.00							
100	Hardinge CNC LATHE SMALL								
Doosan		0.00							
Doosan Lathe	Memo Machine as per Folio FA203 deburr all sharp edges as per dwg	<u>SA</u> <u>12/7/19</u>							
110		0.00							
110	QC2- Inspect parts off machine FAI/FAIB								
QC		0.00							
Quality Control	Memo	<u>SA</u> <u>12/7/19</u>							
120		0.00							
120	QC8- Inspect parts - second check								
QC		0.00							
Quality Control	Memo	<u>af/7/19</u> <u>12-07-09</u> <u>(K21)</u>							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

21 M6 12.7.10

160

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

160

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:20
3200 F
3:50

21X M7 12/07/10

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

21 6 12-7-10

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Reference:

Approvals: Process Plan: Date:

Tooling:

Run Start *NR1*

QC: Date:

SPC (Y/N):

Date:

Stop *NR2*

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

180

Identify as per dwg & Stock Location: GA

0.00

180

Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

212

12-7-12 S-C

OK 12/7/12

R12-0717

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Picklist Print

June-19-12 8:34:37 AM

Page 1

Work Order ID: 85942

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Parent Item: D2055

D2055

Parent Item Name: Clamp

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP C02.03.07Now turned in houseNG IPP REV:D NOW ON
DOOSAN 10-02-01 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.000		Purchased	No			120	f	66.4230	0.1042	2.193684			
M6061T6R1 000										**		12719	
ROUND BAR 1.00"													

Location	Loc Qty	Loc Code
013	22.42	
121192	22.42	
MAT008	24	
121070	24	
MAT013	20.003	
116406	14.303	
118271	5.7	

1.200

1.200

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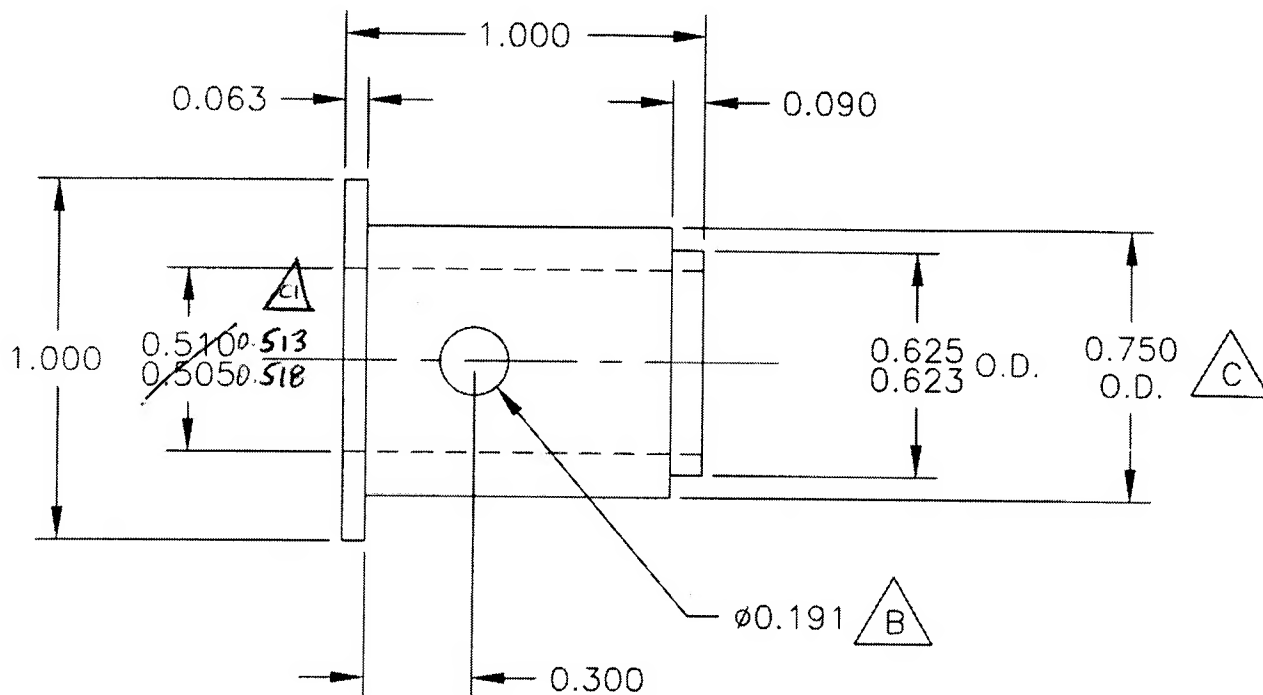
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DESIGN JB		DRAWN BY CP		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE		APPROVED MH		DRAWING NO. D2055	
DATE 98.12.10		TITLE CLAMP		REV. C SHEET 1 OF 1	
A	92.03.13	NEW ISSUE			
B	98.10.15	0.191 DIA WAS 0.187 DIA (TSR A1100) REDRAWN, ADD FINISH			
C	98.12.10	ADDED 0.750 O.D. DIMENSION			
CI	CP 01.06.05	MODIFY HOLE SIZE, ADD P/C OPTION			

RELEASED
98.12.10 KE



SHOP C
RETURN
ENGINE
UNCONTROL
SUBJECT TO
WITH
WORK
NO. 85942 MLJ

12/06/19

ACID ETCH + ALUMINE PER
DACT QSI OOS 4.1
POWDER COAT BLACK SAMTEX (4.3.5.?)
PER DACT QSI OOS 4.3

MATERIAL: 6061-T6 ROD (QQ-A-225/8) ^{PER DART QSI}
FINISH: BLACK ANODIZE OR
BREAK ALL SHARP EDGES 0.015 MAX
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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